

43

Date: Tuesday, 10/2/2007 10:43:51 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FRAME
Job Number : 34941A
Estimate Number : 10300
P.O. Number : N/A Part Number : D32241
This Issue : 10/2/2007 S.O. No. : N/A Drawing Number : D3224 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
Previous Run : 32816A Material : N/A
Written By : Due Date : 10/22/2007 Qty: 4 Um: Each
Checked & Approved By : 07.10.02
Comment : Est Rev A New Issue 05-11-06 JLM
Est: B 06.11.15 waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 5.4600 sf(s)/Unit Total : 21.8400 sf(s)

2024-T3 .063 thick aluminum sheet

Batch: M105615 HB 07-10-16

2.0 WATER JET M105615 FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3224

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

HB 07-10-16

HB 07-10-10

4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 07/10/17 ccw

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

n/a

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FRAME

Job Number: 34941A

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

SB 07/12/19

(4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 7/12/19 (x4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ

07-12-20

(x4)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6 7/12/20 (4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 10A

Co

SB 07/12/20

(x4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2007/12/21

Job Completion



2007/12/21

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

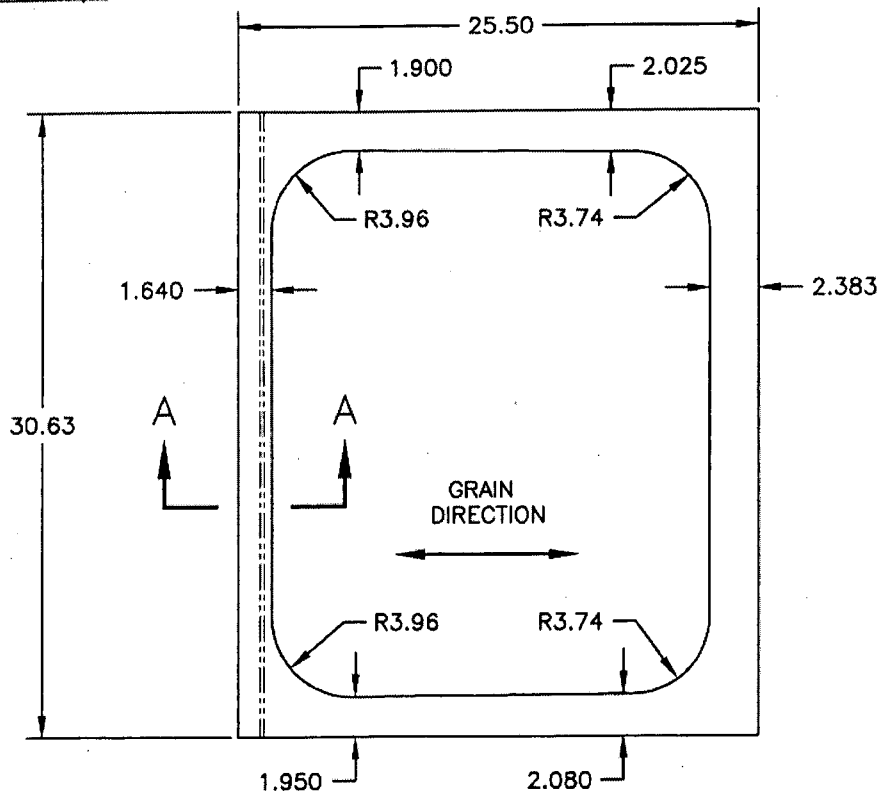
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

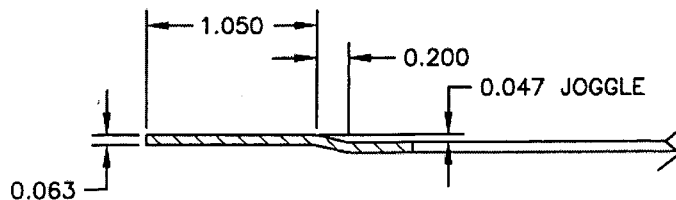


DESIGN #	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3224	REV. A SHEET 1 OF 1
DATE 03.10.21		TITLE FRAME	SCALE NTS
A	03.10.21	NEW ISSUE	

RELEASED
04.02.03



D3224-1



SECTION A-A
SCALE 8:1

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 34941A

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